

Blue

Dart Aerospace Ltd.

Date: Wednesday, 12/11/2008 1:41:16 PM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BLUE - LUG EXTRUSION
Job Number	: 43389	Part Number	: D27317
Estimate Number	: 10326	Drawing Number	: D2731 REV B
P.O. Number	:	Project Number	: N/A
This Issue	: 12/11/2008	Type	: MACHINED PARTS
Prsht Rev.	: NC	Drawing Revision	: B
First Issue	: //	Material	:
Previous Run	: 42568	Due Date	: 10/12/2008
Written By	:	Qty:	100
Checked & Approved By	: JDU 08.11.12	Um:	Each
Comment	: Est D 00.05.19 Added inspect level 8, removed P/O powder coating EC		

Additional Product

Split 1

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D2423	Lug Extrusion	
	Comment: Qty.: 0.0717 f(s)/Unit Total : 7.1715 f(s) Lug Extrusion D2423 Batch: B43722		
2.0	BAND SAW	BAND SAW	
	Comment: BAND SAW Cut D2423 extrusion to .82" Batch _____		
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
			 <i>7/10, 7584 C00811#14 use 7/10 meter</i>
	Comment: HAAS CNC VERTICAL MACHINING #1 1-Machine as per folio D2731-7. 2-Check for crack while loading into the machine. 3-Tumble 4-Deburr any rough edges after tumbling		
4.0	QC8	INSPECT PARTS AS THEY COME OFF MACHINE	
			 <i>rec'd. record + inspect for transited damage attached n+c</i>
5.0	QC8	SECOND CHECK	
			 <i>5/10/08 count</i>
	Comment: SECOND CHECK		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 12/11/2008 1:41:16 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BLUE - LUG EXTRUSION

Job Number: 43389

Part Number: D27317

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 HAND FINISHING1



HAND FINISHING RESOURCE #1

(180)

Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

Fd 09/01/12

7.0 SPRAY PAINTING



SPRAY PAINTING



Comment: -PRIME B 110199

-PAINT DELFLEET BLUE B 110077

M 09 01 27

(X30)

-CLEAR DELFLEET B 110161

(Y30)

8.0 QC14



INSPECT SPRAY PAINT



Zt 09 . 01 - 28

Comment: INSPECT POWDER COAT

9.0 PACKAGING 1



PACKAGING RESOURCE #1



(30)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: Store

9/1/28

Sc

10.0 QC21



FINAL INSPECTION/W/O RELEASE



09/01/28 AF

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 09-01-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	43389
Description: Lug	Part Number:	D2731-7
Inspection Dwg: D2731	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:

Audited by:

Prototype Approval: N/A

Date: _____

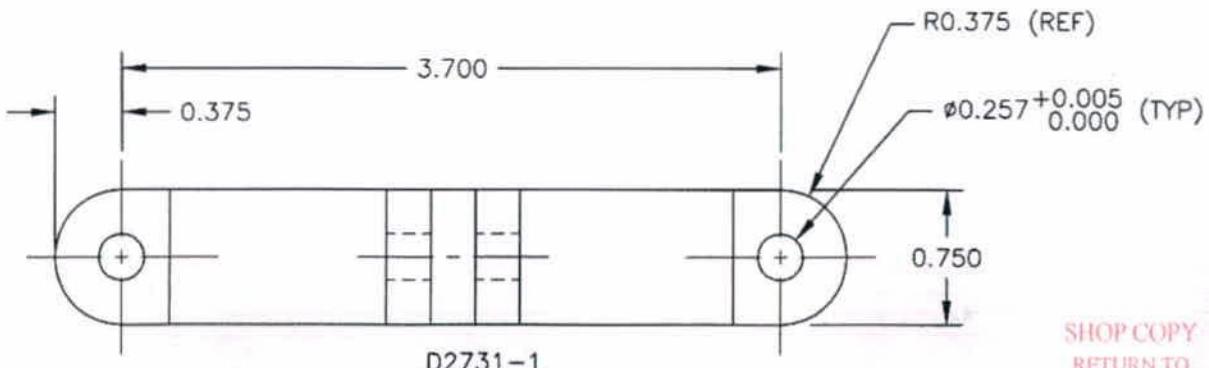
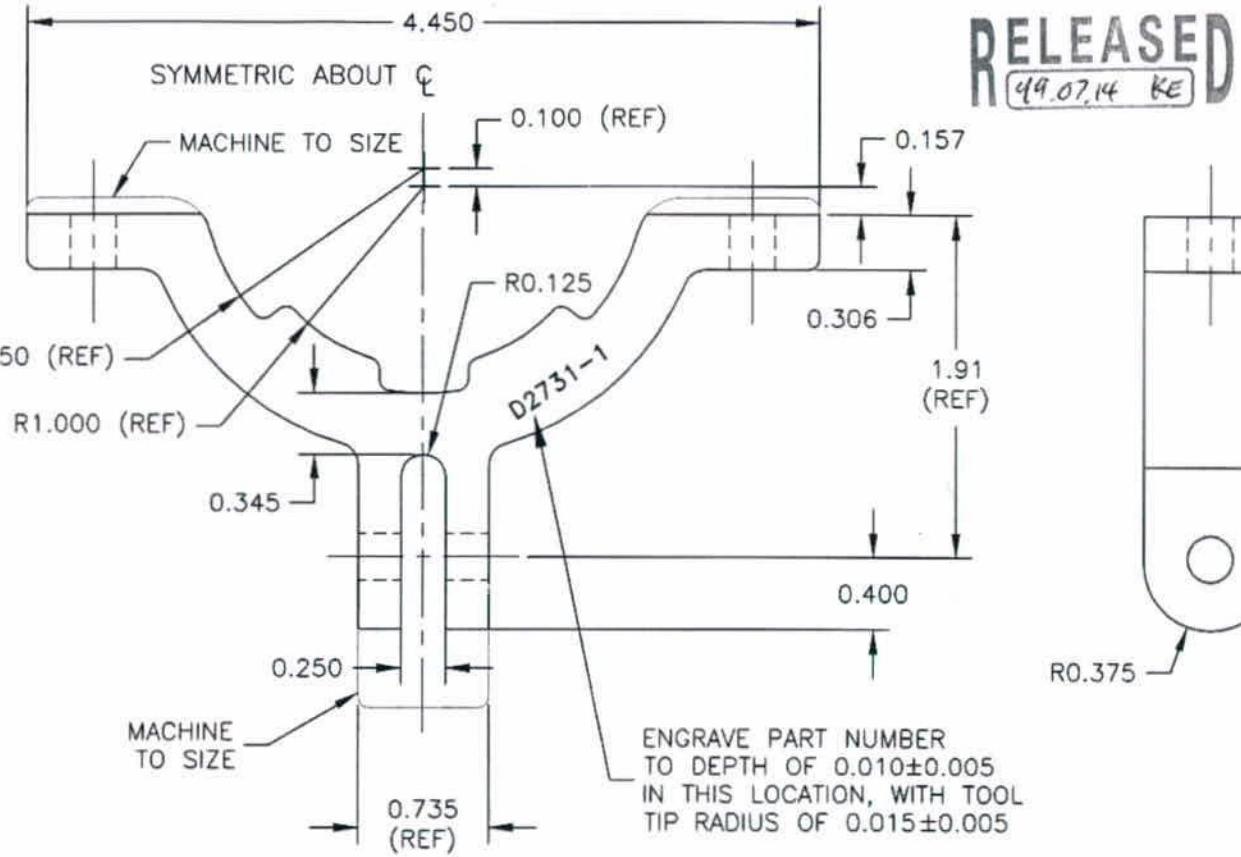
Date:

Date: N/A

Rev	Date	Change	Revised by	Approved
A	04.04.22	New Issue	KJ/RF	
B	04.05.06	Dimension change	KJ/RF 	

DART

DESIGN <i>KE</i>	DRAWN BY <i>RF</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA
CHECKED <i>KE</i>	APPROVED <i>JF</i>	DRAWING NO. D2731
DATE 99.07.06		REV. B SHEET 1 OF 4
		TITLE MOUNTING LUG
		SCALE 1:1
A	98.05.13	NEW ISSUE
B	99.07.06	REVISED DIMENSIONS



MAKE FROM EXTRUSION D2423
BREAK ALL EDGES 0.000-0.015

FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

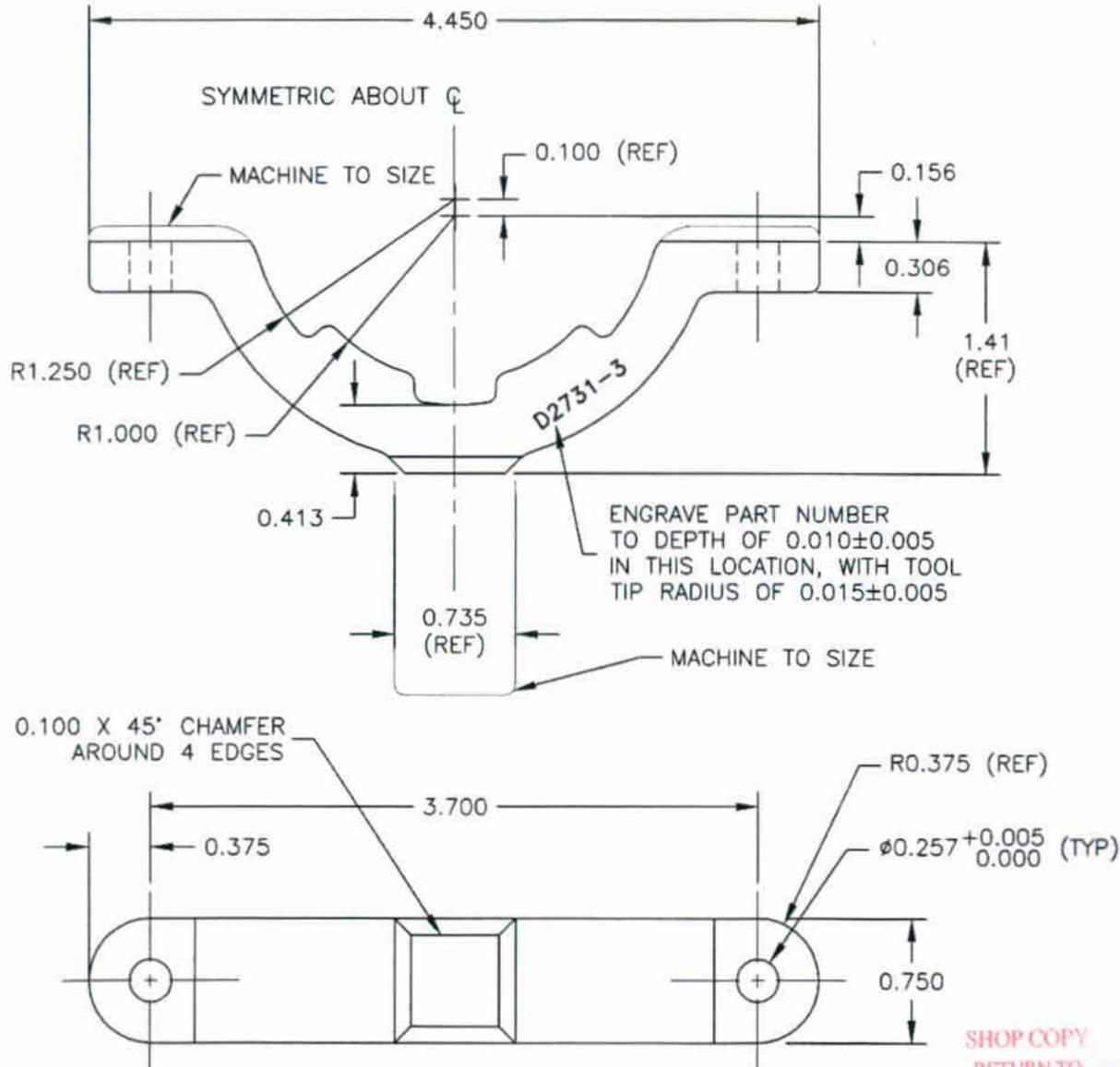
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
NO. 43389

DART

DESIGN <i>KE</i>	DRAWN BY <i>RF</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA
CHECKED <i>KE</i>	APPROVED <i>JF</i>	DRAWING NO. D2731
DATE 99.07.06		REV. B SHEET 2 OF 4 TITLE MOUNTING LUG SCALE 1:1

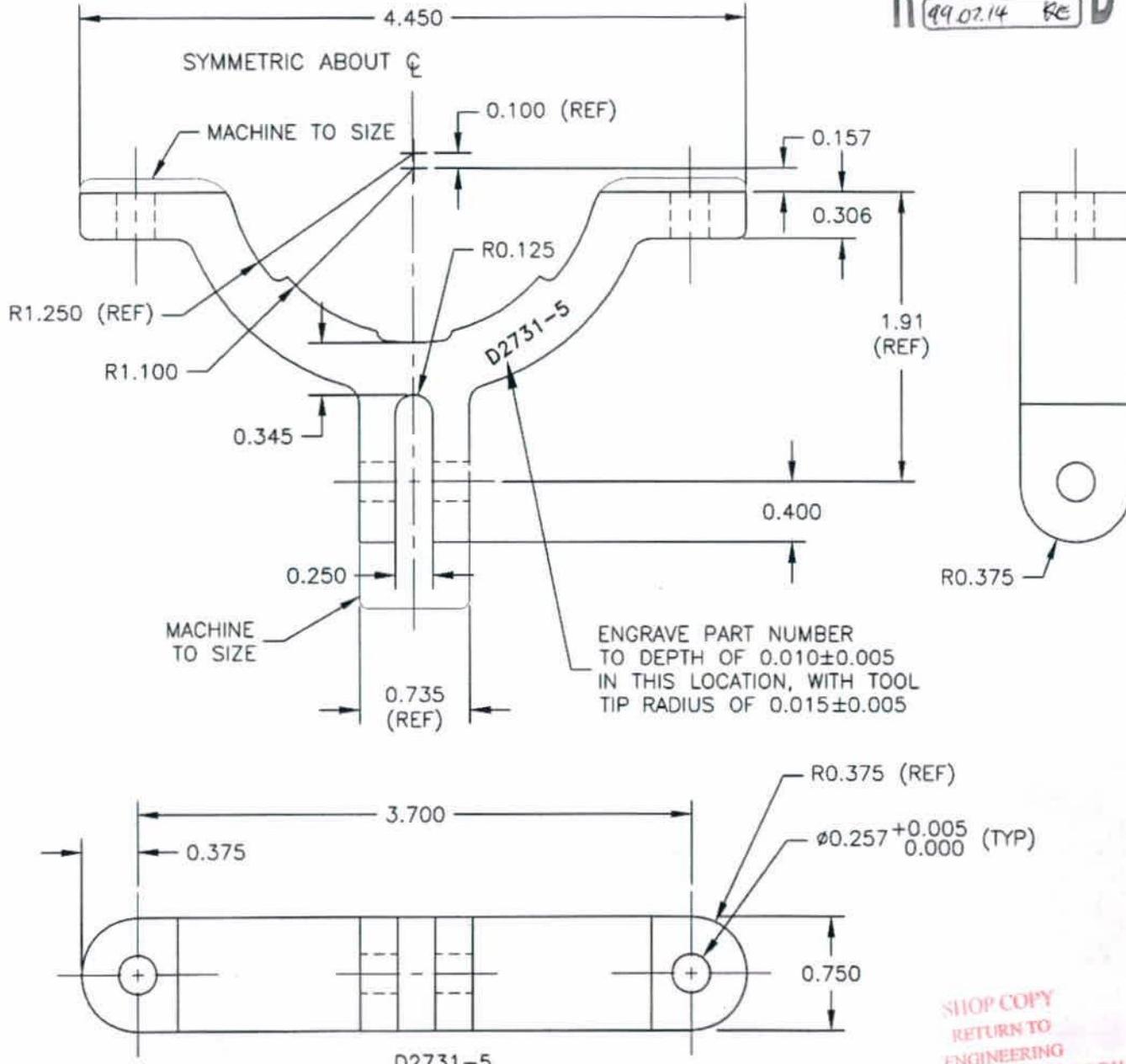
RELEASED
19.07.14 *KE*

MAKE FROM EXTRUSION D2423
BREAK ALL EDGES 0.000-0.015
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 43389

DART

DESIGN <i>KE</i>	DRAWN BY <i>RF</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA
CHECKED <i>KE</i>	APPROVED <i>CS</i>	DRAWING NO. D2731
DATE 99.07.06		REV. B SHEET 3 OF 4 TITLE MOUNTING LUG SCALE 1:1

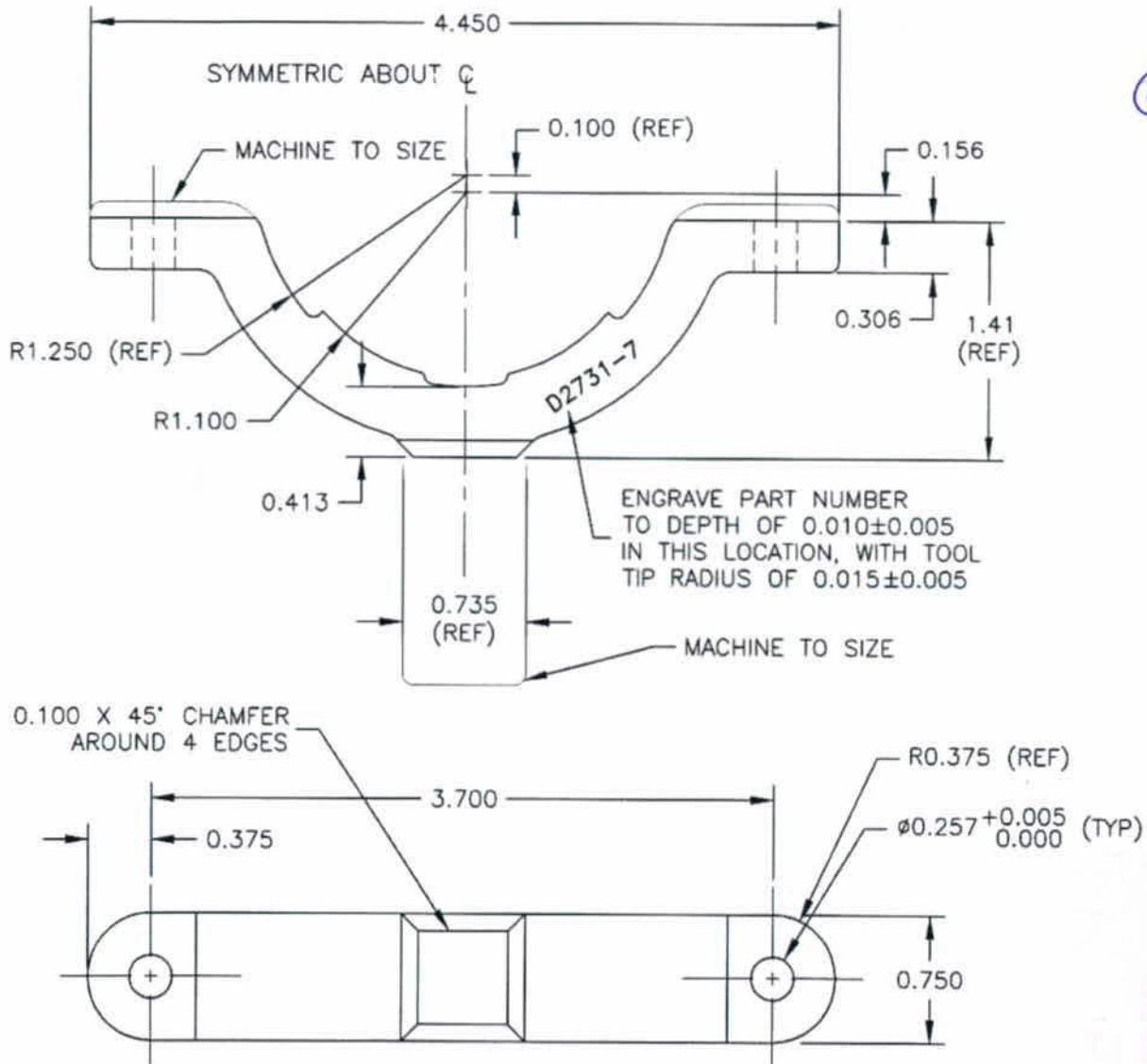
RELEASED
99.07.14 *KE*

MAKE FROM EXTRUSION D2423
BREAK ALL EDGES 0.000–0.015
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
NO 43389

DART

DESIGN <i>KE</i>	DRAWN BY <i>RF</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA
CHECKED <i>KE</i>	APPROVED <i>SJ</i>	DRAWING NO. D2731
DATE 99.07.06		REV. B SHEET 4 OF 4 TITLE MOUNTING LUG SCALE 1:1

RELEASED
99.07.14 *KE*

MAKE FROM EXTRUSION D2423
BREAK ALL EDGES 0.000–0.015
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 43389



CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PAR NAME</u>	<u>P.O. NUMBER</u>
100	D2731-7	Mounting Lug	7584

MATERIAL: supplied by DART D2423 B43722

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

A handwritten signature in black ink, appearing to read "Shigi Walz".
Shigi Walz

A handwritten signature in blue ink, appearing to read "S. Orlando".

Vankleek Hill, January 7, 2009